

NAR-19-7721



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6510G04631-6F-3**Job Sheet 199041****Part No:** RBW6510G04631-6F-3**Job Qty:** 2 pcs**Part Name:** Reaction**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/9/19**Job Tracking No:****Due Date:** 10/21/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBW6510G04631-6F Rev A IPP Rev. A 19.08.08 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	NLX 2500SY - 1	2 pcs	10/21/19	10/21/19	1.00	2.00	NLX 2500SY - 1		
110	QC 2	2 pcs	10/21/19	10/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

**Container No:** S218967**Part:** RBW6510G04631-6F-3**Job No:** 199041**Serial No/Batch:** S218967**Revision:** A**Inspector:****Exp Date:****Instructions:****Date:** 10/02/19

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Plex 8/9/19 2:35 PM Dart.lajeunesse.marie

					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	HAAS 5 Axis - B4B	2 pcs	10/21/19	0.75 1.00	HAAS - 5 - B4B	S.C.L
130	QC 2	2 pcs	10/21/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	S.C.L. 09-10-03
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
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					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	2 pcs	10/21/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	S.A 19-11-06
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	

150 Packaging 3-1 - Stock - B4B 2 pcs	10/21/19	0.00 0.00	QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
160 QC 21 - SA <i>SA</i> 2 pcs	10/21/19	0.00 0.00	Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			QC 21 - SA - 21	
			QC 21 - SA - 70	

160 QC 21 - SA *SA* 2 pcs

10/21/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

NOV 07 2019

Part Op 100 - 1-Machine as per folio FC 991 FOLIO REV: AA DWG REV: A 2-Debur 3

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

~~120~~ - 1-Machine as per folio FC 991 FOLIO REV: AA DWG REV: A 2-Debur

130 - QC2- Inspect parts off machine FAI/FAIB

140 - QC8- Inspect parts - second check

150 - Identify as per dwg & Stock Location: W/A

160 - QC21- Final Inspection - Work Order Release

19-9-20
DAS
45
9-89

3-11-14-15-16-17-18-19-20-21-22-23-24-25-26-27-28-29-30-31-32-33-34-35-36-37-38-39-40-41-42-43-44-45-46-47-48-49-50-51-52-53-54-55-56-57-58-59-60-61-62-63-64-65-66-67-68-69-70-71-72-73-74-75-76-77-78-79-80-81-82-83-84-85-86-87-88-89-90-91-92-93-94-95-96-97-98-99-100-101-102-103-104-105-106-107-108-109-110-111-112-113-114-115-116-117-118-119-120-121-122-123-124-125-126-127-128-129-130-131-132-133-134-135-136-137-138-139-140-141-142-143-144-145-146-147-148-149-150-151-152-153-154-155-156-157-158-159-160-161-162-163-164-165-166-167-168-169-170-171-172-173-174-175-176-177-178-179-180-181-182-183-184-185-186-187-188-189-190-191-192-193-194-195-196-197-198-199-200-201-202-203-204-205-206-207-208-209-210-211-212-213-214-215-216-217-218-219-220-221-222-223-224-225-226-227-228-229-230-231-232-233-234-235-236-237-238-239-240-241-242-243-244-245-246-247-248-249-250-251-252-253-254-255-256-257-258-259-260-261-262-263-264-265-266-267-268-269-270-271-272-273-274-275-276-277-278-279-280-281-282-283-284-285-286-287-288-289-290-291-292-293-294-295-296-297-298-299-300-301-302-303-304-305-306-307-308-309-310-311-312-313-314-315-316-317-318-319-320-321-322-323-324-325-326-327-328-329-330-331-332-333-334-335-336-337-338-339-340-341-342-343-344-345-346-347-348-349-350-351-352-353-354-355-356-357-358-359-360-361-362-363-364-365-366-367-368-369-370-371-372-373-374-375-376-377-378-379-380-381-382-383-384-385-386-387-388-389-390-391-392-393-394-395-396-397-398-399-400-401-402-403-404-405-406-407-408-409-410-411-412-413-414-415-416-417-418-419-420-421-422-423-424-425-426-427-428-429-430-431-432-433-434-435-436-437-438-439-440-441-442-443-444-445-446-447-448-449-450-451-452-453-454-455-456-457-458-459-460-461-462-463-464-465-466-467-468-469-470-471-472-473-474-475-476-477-478-479-480-481-482-483-484-485-486-487-488-489-490-491-492-493-494-495-496-497-498-499-500-501-502-503-504-505-506-507-508-509-510-511-512-513-514-515-516-517-518-519-520-521-522-523-524-525-526-527-528-529-530-531-532-533-534-535-536-537-538-539-540-541-542-543-544-545-546-547-548-549-550-551-552-553-554-555-556-557-558-559-560-561-562-563-564-565-566-567-568-569-570-571-572-573-574-575-576-577-578-579-580-581-582-583-584-585-586-587-588-589-590-591-592-593-594-595-596-597-598-599-600-601-602-603-604-605-606-607-608-609-610-611-612-613-614-615-616-617-618-619-620-621-622-623-624-625-626-627-628-629-630-631-632-633-634-635-636-637-638-639-640-641-642-643-644-645-646-647-648-649-650-651-652-653-654-655-656-657-658-659-660-661-662-663-664-665-666-667-668-669-670-671-672-673-674-675-676-677-678-679-680-681-682-683-684-685-686-687-688-689-690-691-692-693-694-695-696-697-698-699-700-701-702-703-704-705-706-707-708-709-710-711-712-713-714-715-716-717-718-719-720-721-722-723-724-725-726-727-728-729-730-731-732-733-734-735-736-737-738-739-740-741-742-743-744-745-746-747-748-749-750-751-752-753-754-755-756-757-758-759-760-761-762-763-764-765-766-767-768-769-770-771-772-773-774-775-776-777-778-779-780-781-782-783-784-785-786-787-788-789-790-791-792-793-794-795-796-797-798-799-800-801-802-803-804-805-806-807-808-809-810-811-812-813-814-815-816-817-818-819-820-821-822-823-824-825-826-827-828-829-830-831-832-833-834-835-836-837-838-839-840-841-842-843-844-845-846-847-848-849-850-851-852-853-854-855-856-857-858-859-860-861-862-863-864-865-866-867-868-869-870-871-872-873-874-875-876-877-878-879-880-881-882-883-884-885-886-887-888-889-890-891-892-893-894-895-896-897-898-899-900-901-902-903-904-905-906-907-908-909-910-911-912-913-914-915-916-917-918-919-920-921-922-923-924-925-926-927-928-929-930-931-932-933-934-935-936-937-938-939-940-941-942-943-944-945-946-947-948-949-950-951-952-953-954-955-956-957-958-959-960-961-962-963-964-965-966-967-968-969-970-971-972-973-974-975-976-977-978-979-980-981-982-983-984-985-986-987-988-989-990-991-992-993-994-995-996-997-998-999-1000-1001-1002-1003-1004-1005-1006-1007-1008-1009-1010-1011-1012-1013-1014-1015-1016-1017-1018-1019-1020-1021-1022-1023-1024-1025-1026-1027-1028-1029-1030-1031-1032-1033-1034-1035-1036-1037-1038-1039-1040-1041-1042-1043-1044-1045-1046-1047-1048-1049-1050-1051-1052-1053-1054-1055-1056-1057-1058-1059-1060-1061-1062-1063-1064-1065-1066-1067-1068-1069-1070-1071-1072-1073-1074-1075-1076-1077-1078-1079-1080-1081-1082-1083-1084-1085-1086-1087-1088-1089-1090-1091-1092-1093-1094-1095-1096-1097-1098-1099-1100-1101-1102-1103-1104-1105-1106-1107-1108-1109-1110-1111-1112-1113-1114-1115-1116-1117-1118-1119-1120-1121-1122-1123-1124-1125-1126-1127-1128-1129-1130-1131-1132-1133-1134-1135-1136-1137-1138-1139-1140-1141-1142-1143-1144-1145-1146-1147-1148-1149-1150-1151-1152-1153-1154-1155-1156-1157-1158-1159-1160-1161-1162-1163-1164-1165-1166-1167-1168-1169-1170-1171-1172-1173-1174-1175-1176-1177-1178-1179-1180-1181-1182-1183-1184-1185-1186-1187-1188-1189-1190-1191-1192-1193-1194-1195-1196-1197-1198-1199-1200-1201-1202-1203-1204-1205-1206-1207-1208-1209-1210-1211-1212-1213-1214-1215-1216-1217-1218-1219-1220-1221-1222-1223-1224-1225-1226-12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Part Specifications
Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	199041
Description: Reaction		Part Number:	RBW6510-G04631-GF-3
Inspection Dwg: RBW6510-G04631-GF Rev: A		Page 1 of 1	

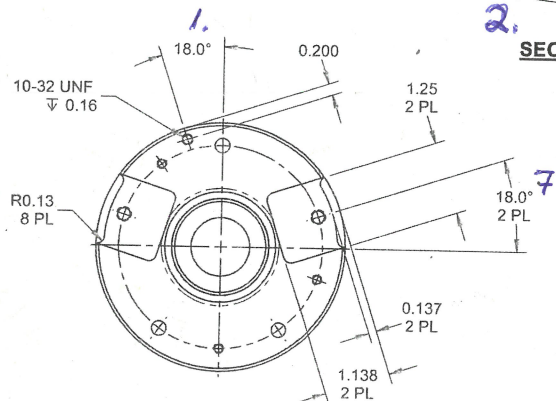
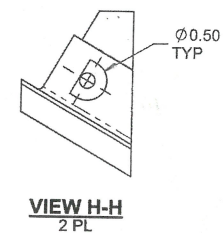
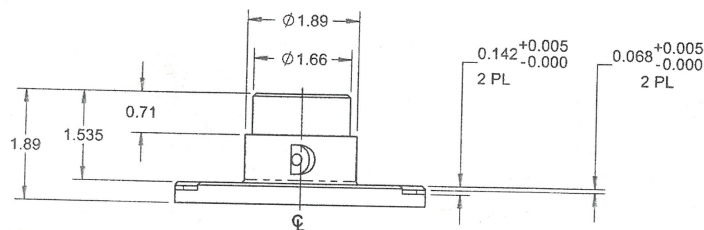
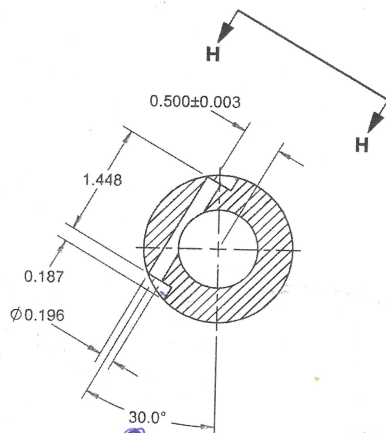
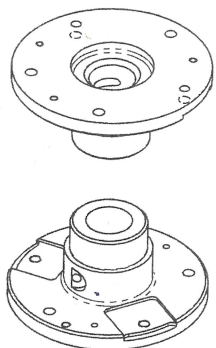
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10-32 UNF	GO-NO GO	GO	✓		GO-NO GO	
.16	$\pm .01$	.170	✓		Vern LPI	
.200	$\pm .005$	.198	✓		↓	
R.13	$\pm .01$	.170	✓		Pin Edge	
1.138	$\pm .005$	1.134	✓		caliper	JCL-08
.137	$\pm .005$	.137	✓			
1.25	$\pm .01$	1.255	✓			
.500	$\pm .003$	.497			H-gauge	
1.448	$\pm .005$	1.449			Vern LPI	
.187	$\pm .005$	.190			↓	
Ø.196	$\pm .005$	.196			gauge Pin	
.769	$\pm .005$	.7715			H-gauge	
1.89	$\pm .01$	1.888			Vern LPI	
1.535	$\pm .005$	1.535			H-gauge	
.71	$\pm .01$	.709			↓	
Ø1.89	$\pm .01$	1.890			Vern LPI	
Ø1.66	$\pm .01$	1.660			↓	
.142	$\pm .005/-0.000$	.147	✓		Depth Gauge	JCL-09
.068	$\pm .005/-0.000$	0.064	✓			
Ø.50	$\pm .01$	.495			Gauge Pin	
Ø.249/.250		.2496			CHM	
Ø3-.476	$\pm .001$	3.4756			C.M.M	
1/4-28	GO/NO GO	GO			GO-NO GO	
Ø1.77	$\pm .01$	1.770			Vern LPI	
Ø4.253	$\pm .005$	4.248			↓	
Ø1.000/1.002		1.0015			Mic LPI	
B-32 UNC	GO-NO GO	GO			GO-NO GO	
.223	$\pm .005/-0.000$	.226			H-gauge	
10 x 45°	$\pm .01 \times .5°$	10 x 45°	✓		Vern LPI	

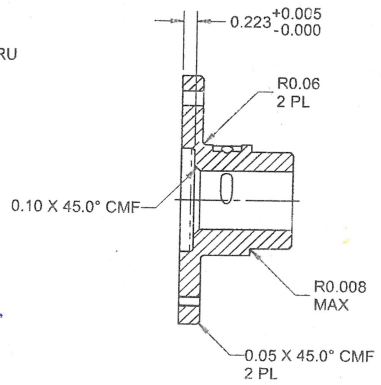
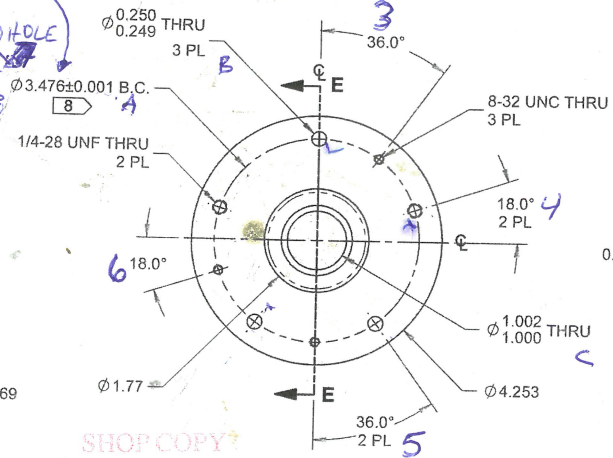
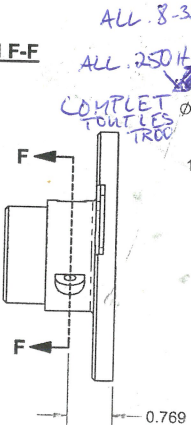
Measured by:	J/S.C.V.	Checked by:	B.O.	QC Inspector:	
Date:	19-10-02	Date:	19-11-06	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



SECTION F-F



SECTION E-E

RBW6510G04631-6F-3 REACTION

- NOTES:
- 1) MATERIAL: 4140
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) SYMMETRIC TOLERANCE OF ±0.001 ONLY APPLICABLE FOR DOWEL PIN HOLES OF Ø0.2500-0.2492

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WITHOUT NOTICE
WORK ORDER

NO. 199041 M/S
19-08-09

DESIGN DRAWN CHECKED MFG. APPR. APPROVED	KPT KPT VM FK WJ	DATE 2019-07-09	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
			TOOL PART # RBW6510G04631-6F	SHEET 5 OF 10
			TITLE REACTION ASSEMBLY	SCALE NTS
			COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered:

LR

Date:

Nov 18/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

19-7721

Route update only ☐

Job: <u>199041</u> Part No. <u>RBW6501G-04631-6F-3</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date: <u>11/5/2019</u>	Sequence #: <u>100</u>	QTY Affected: <u>6</u>		MRB (QSI042) <u>19-11-05</u>			
Description Work Order Deviation DIMENSION WAS $\phi 3.476 \pm 0.001$ DIMENSION IS $\phi 3.476 \pm 0.005$ IT IS ACCEPTABLE FOR $\phi 1.002 - 1.000$ HOLE TO BE UNDERSIZED TO $\phi 0.9997$ OR $\phi 0.9998$			Disposition THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED		Completed By Lead hand / Supervisor QC / QA Coordinator DAS 9 9-89 <u>19-11-07</u>		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐			FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ ☒ Outside Tolerance Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
Other/Details:							